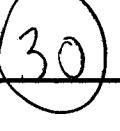
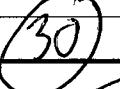
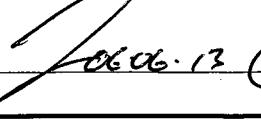
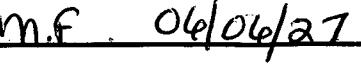
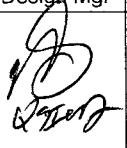
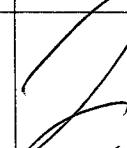
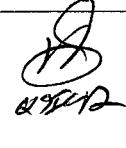


Date: Monday, 6/12/2006 2:25:45 PM  
User: Kim Johnston

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 27485				
Estimate Number	: 10330				
P.O. Number	: N/A		Part Number	: D2746	
This Issue	: 6/12/2006 S.O. No. : N/A		Drawing Number	: D2746 REV C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C	
Previous Run	: 25841		Material	: N/A	
Written By	<u>See off comment below</u>		Due Date	: 6/30/2006	
Checked & Approved By	<u>Off Dwg. 12</u>			Qty:	30
Comment				Um:	Each
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	WATER JET	FLOW WATER JET 			
Comment: FLOW WATER JET 1-Cut as per Dwg D2746 Dwg Rev: <u>C</u> Prog Rev: <u>C</u>					
2-Deburr if necessary  					
2.0	M1010S20GA	1010/1025/A21/6aA SHEET 			
Comment: Qty.: 0.4263 sf(s)/Unit Total : 12.7890 sf(s) 1010/1025/A21/6aA .040" SHEET (M1010S20GA) Batch: <u>M100473</u>  					
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  					
4.0	QC8	SECOND CHECK 			
Comment: SECOND CHECK 					
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. 					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
6/6/13	1.0						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/13	1.0	2 pieces scrap because holes did not cut all the way around (cut and scrap)		Cvt 2 and replace.	MM MM 06/06/13			06-06-13

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes DQA: 

Date: 06/07/13

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 6/12/2006 2:25:45 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27485

Part Number: D2746

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326  
2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746

SB 06/06/27

30

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 07 05

30

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06-07-05

30

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP20

FC 06 07 05 30

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/06 30

Job Completion



06-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

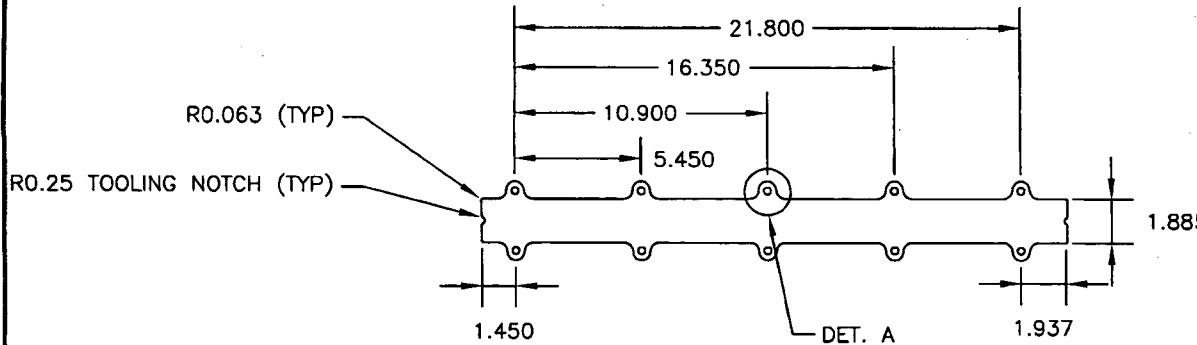
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

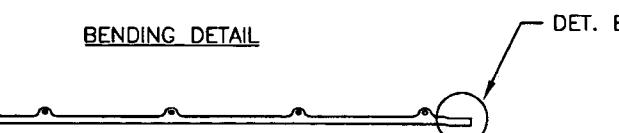
NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART****RELEASED**  
06-02-07**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA  
REV. C  
SHEET 1 OF 1  
SCALE 1:8

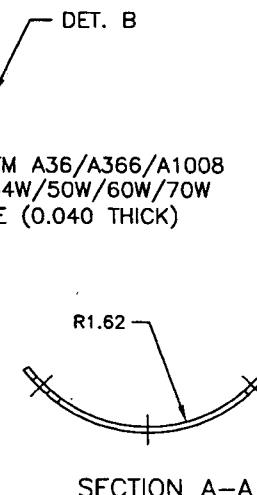
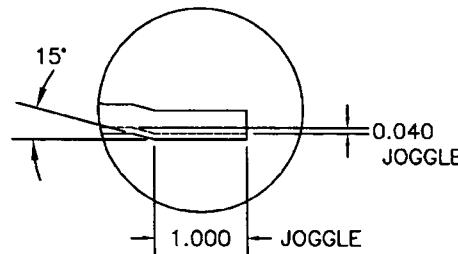
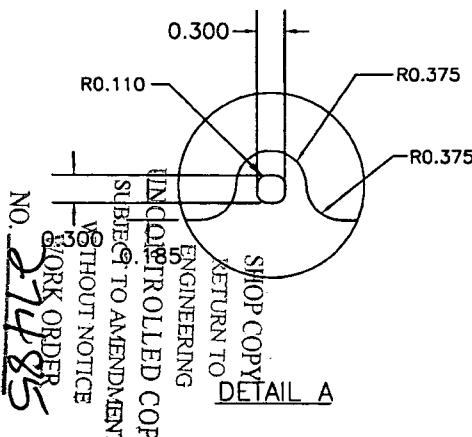
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO.
DATE		TITLE
A	PH	98.04.16 NEW ISSUE
B	PH	98.08.18 RE-DESIGN
C	PH	06.01.12 ENLARGE HOLES TO IMPROVE FIT

FLAT PATTERNBENDING DETAIL

A-A



MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)

**NOTES**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

DART AEROSPACE LTD		Work Order:	27485
Description:	WEARShoe	Part Number:	2746
Inspection Dwg:	Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article

x Prototype

Measured by:	<u>MM</u>	Audited by:	<u>J</u>	Prototype Approval:	<u>N/A</u>
Date:	<u>06.06.13</u>	Date:	<u>06.06.13</u>	Date:	<u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	